

Work Order ID 133221

133221

Page 1

May-27-15 12:35:17 PM

Item ID: D5253-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 27/05/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/05/2015 Req'd Qty: 12.00

12

Customer:

Reference:

JS 15.05.27

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5253	A								

100

Manufacture as per dwg

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

13 0 J.C.L. 15/05/28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13 0 J.C.L. 15/05/28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

13 0 DAS 44 9-89 15/05/28

Work Order ID 133221

May-27-15 12:35:17 PM

133221

Page 2

Item ID: D5253-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 27/05/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/05/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAY 28 2015

MAY 29 2015

MAY 29 2015

Picklist Print

May-27-15 12:35:16 PM

Page 1

Work Order ID: 133221

133221

Parent Item: D5253-1

D5253-1

Parent Item Name: Shim

Start Date: 27/05/2015

Required Date: 29/05/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 15.05.27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.125X04.000		Purchased	No				f	0.0000		1			
M304B0 125X04 000									**				
304 BAR .125 X 4.000"													

304 0.125

M304S 11 GA

122 521

0.166'

J.C.L. 15/05/27

X (Not pulled off the system) X

DQA: _____ Date: _____

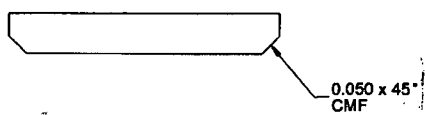
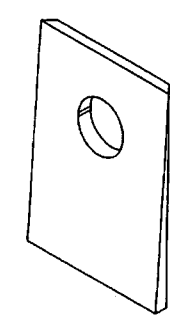
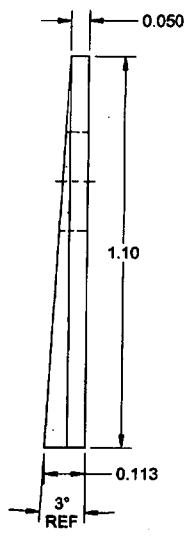
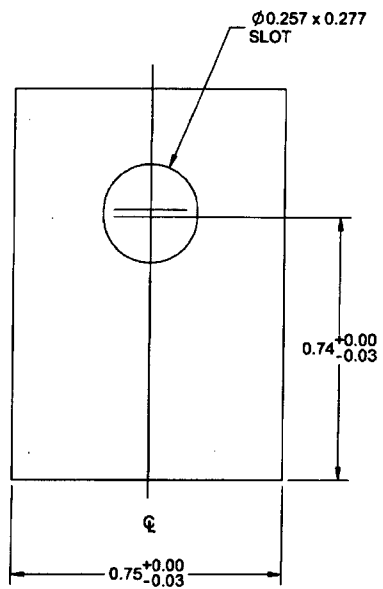


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



D5253-1 SHIM

RELEASED
 2015 MAY 26
 ECN 15-571

- NOTES:**
- 1) MATERIAL: AISI 303/304/316 SS BAR OR 303/304/316 SS PLATE
 PER ASTM A582 (303)
 PER ASTM 276 OR ASTM 240 (304/316)
 REF DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

APPROVED

REVISED

A		NEW ISSUE		RF	15.05.11	
REV.		DESCRIPTION			BY	DATE
DESIGN		RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		RF				
CHECKED		VS		DRAWING NO.		REV. A
MFG. APPR.		JLM		D5253		SHEET 1 OF 1
APPROVED		HS		TITLE		SCALE
DE APPR.		DS		SHIM		NTS
DATE		15.05.11				

Copyright © 2015 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

COPYRIGHT © 2015 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.